



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041
Job Sheet 185681



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Large Fab-5		<i>W</i> 20/11/18
100	Large Fab	1 pcs	11/23/18	11/23/18	0.00	10.00	Large Fab 1		<i>W</i> 20/11/18
110	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC9		<i>CPC</i>
120	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC5		<i>CPC</i>
125	HandFinish	1 pcs	11/23/18	11/23/18	0.00	0.29	HandFinish2		<i>BH</i> 18-11-21
130	Powdercoat	1 pcs	11/23/18	11/23/18	0.00	0.93	Powdercoat2		<i>BR</i> 18-11-21
135	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging1		<i>W</i> 18-11-21
140	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC3		<i>W</i> 18-11-21
150	HandFinish	1 pcs	11/23/18	11/23/18	0.00	0.50	HandFinish4		<i>W</i> 18-11-21
160	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC5		<i>DAS</i> 18-11-21
170	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-2		<i>W</i> 18-11-21
180	QC21-SA	1 Ea	11/23/18	11/23/18	0.00	0.00	QC21		<i>DAS</i> 18-11-21

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138951

START: 1:20 OUT: 3:35 FINISH: 1:35

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>S 108 601</i>
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	<i>S 108 592</i>
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	<i>S 112 730</i>
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	<i>S 115 925</i>
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	<i>S 116 572</i>
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	<i>S 122 708</i>
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	<i>S 123 065</i>
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	<i>S 112 356</i>
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	<i>S 110 037</i>
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	<i>S 115 755</i>
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	

006561

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5109707
 2x 5108590-1K 5115200
 5116607
 5116606
 5114035
 5093684
 5106952
 F86437
 5076007
 5094592-1
 5109991-1
 5108637

Job Allocations

006597

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	42	0
	D3913-1	1	1	0
	D3913-15	1	16	0
	D3913-3	1	2	0
	D3913-7	2	16	0
	D3913-9	1	8	0
	D3916-041	2	8	0
	D3916-5	3	11	0
	D4016-1	3	214	0
	D4017-7	3	10	0
	D4017-9	2	16	0
	D4020-11	2	21	0
	D4021-1	3	25	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	6	0
	M304EX0.75-16F	33	1,189	0
	AN3-10A	6	137	0
	D2931	2	928	0
	D4021-5	2	37	0
150-HandFinish	MS20600-AD4W3	2	319	0
	MS21042L3	6	2,363	0
	NAS1149F0332P	12	2,093	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

DART AEROSPACE Container No: S129597 Part: D3913 - 041 Job No: 185681 Serial No/Batch: S129597 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/20/18 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com		DISPOSITION		
		AGAINST DEPARTMENT/PROCESS		
		☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite	☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier	☐ Engineering ☐ Quality ☐ Other
		tive : _____		
		Disposition		
		Completed By		
		Lead hand / Supervisor Approval Verification		
		QC / QA Coordinator Approval		

Root Cause		FAULT CATEGORY	
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes
☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	OTHER : _____	